



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4202-1
Job Sheet 182763



Part No: D4202-1

Job Qty: 150 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/28/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	150 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Machining-2		JSO 10/10/18
100	Hardinge	150 pcs	9/28/18	9/28/18	0.00	6.38	Hardinge		" "
120	QC	150 pcs	9/28/18	9/28/18	0.00	0.00	QC8		Rt 2018-10-25
130	Outsource	150 pcs	9/28/18	9/28/18			MEI001-VC	9	67 18-10-25
140	Packaging	150 pcs	9/28/18	9/28/18	0.00	0.00	Packaging2		NOV 09 2018
150	QC	150 pcs	9/28/18	9/28/18	0.00	0.00	QC6		NOV 09 2018
160	HandFinish	150 pcs	9/28/18	9/28/18	0.00	0.75	HandFinish4		9-89
190	Packaging	150 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-2		
200	QC21-SA	150 Ea	9/28/18	9/28/18	0.00	0.00	QC21		DAS

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6
160 - WASH SPACER AS PER QSI005
190 - ***STOCK IN SKIDTUBE CELL ***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	52.5000 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.058	53	76	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches ± 0.010	0.510 0.490	Product	
2	Spacer	0.058inches ± 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

Plex 8/31/18 10:38 AM dart.white.jesse

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S121344



Part: D4202-1

Job No: 182763

Serial No/Batch: S121344

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/25/18

72-0000
TC-01

WDS-1000



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041466**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO041466
PO Date: 10/25/18
Due Date: 11/16/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
OCT 30 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182760	D4202-1	Spacer : Various STC's ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	11/16/18	150 pcs	0 pcs	150 pcs	\$2.225/pcs	\$333.75
	182763			Firmed	-	11/16/18	150 pcs	0 pcs	150 pcs	\$2.225/pcs	\$333.75
Sub Total:							300	0	300		\$667.50

Grand Total: \$667.50

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/25/18 1:16 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331457	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41466	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	30	41 - 41,5 %IACS
HARDNESS	60 HREW MIN	30	64 - 65,5 HREW
			MESURE EN HR15TW = 64,5-65,5 HR15TW (912)

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
300	10,75	D4202-1 (150) D4202-1 JOB 182760 (150) D4202-1 JOB 182763 1 BOITE DE CARTON

DAS
68
9-89

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-11-09

Pierre Piché
Chief Inspector



